

POLYLAC® PA-777E

Acrylonitrile Butadiene Styrene

CHI MEI CORPORATION

Message:

POLYLAC® PA-777E is an Acrylonitrile Butadiene Styrene (ABS) product. It can be processed by injection molding and is available in Africa & Middle East, Asia Pacific, Europe, Latin America, or North America.

Characteristics include:

Flame Rated

RoHS Compliant

General Information			
UL YellowCard	E56070-245750		
RoHS Compliance	RoHS Compliant		
Processing Method	Injection Molding		
Physical	Nominal Value	Unit	Test Method
Specific Gravity	1.07	g/cm ³	ASTM D792, ISO 1183
Melt Mass-Flow Rate (MFR) (220°C/10.0 kg)	4.0	g/10 min	ASTM D1238
Melt Volume-Flow Rate (MVR) (220°C/10.0 kg)	4.00	cm ³ /10min	ISO 1133
Hardness	Nominal Value	Unit	Test Method
Rockwell Hardness (R-Scale)	115		ASTM D785
Ball Indentation Hardness (H 358/30)	99.0	MPa	ISO 2039-1
Mechanical	Nominal Value	Unit	Test Method
Tensile Stress			
Yield	44.0	MPa	ISO 527-2/50
Break	37.0	MPa	ISO 527-2/50
3.00 mm ¹	44.1	MPa	ASTM D638
Tensile Elongation			
Break, 3.00 mm ²	10	%	ASTM D638
Break	13	%	ISO 527-2/50
Flexural Modulus			
6.00 mm ³	2260	MPa	ASTM D790
-- ⁴	2200	MPa	ISO 178
Flexural Strength			
6.00 mm ⁵	68.6	MPa	ASTM D790
-- ⁶	71.0	MPa	ISO 178
Impact	Nominal Value	Unit	Test Method
Charpy Notched Impact Strength	11	kJ/m ²	ISO 179
Notched Izod Impact			
23°C, 3.00 mm	120	J/m	ASTM D256
23°C, 6.00 mm	110	J/m	ASTM D256

--	11	kJ/m ²	ISO 180/1A
Unnotched Izod Impact Strength	95	kJ/m ²	ISO 180/1U
Thermal	Nominal Value	Unit	Test Method
Deflection Temperature Under Load			
1.8 MPa, Unannealed	109	°C	ASTM D648
1.8 MPa, Unannealed	106	°C	ISO 75-2/A
1.8 MPa, Annealed	120	°C	ASTM D648
1.8 MPa, Annealed	118	°C	ISO 75-2/A
Vicat Softening Temperature			
--	129	°C	ASTM D1525, ISO 306/A50 6 ⁷
--	119	°C	ISO 306/B50
Flammability	Nominal Value	Test Method	
Flame Rating (1.60 mm)	HB	UL 94	
Injection	Nominal Value	Unit	
Drying Temperature	100 to 110	°C	
Drying Time	3.0	hr	
Rear Temperature	220 to 250	°C	
Middle Temperature	240 to 270	°C	
Front Temperature	240 to 270	°C	
Mold Temperature	40.0 to 80.0	°C	
Injection Pressure	4.90 to 6.86	MPa	
Holding Pressure	3.92 to 5.88	MPa	
Back Pressure	0.490 to 1.47	MPa	
NOTE			
1.	6.0 mm/min		
2.	6.0 mm/min		
3.	2.8 mm/min		
4.	2.0 mm/min		
5.	2.8 mm/min		
6.	2.0 mm/min		
7.	Rate A (50°C/h)		

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